

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016938**Date Inspected:** 16-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Heavy Dock Jetty

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046769 perform SMAW welding on; Cross Bracing Gusset and Back fill plate on Skin A of East shaft, Lift 3, in 109 mtr. elevation and the weld joint is identified as ESD1-FASA3-2 B/E-27. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4214-TC-U4C. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052910 perform SMAW welding on; Cross Bracing Gusset and Back fill plate on Skin A of West shaft, Lift 3, in 109 mtr. elevation and the weld joint is identified as WSD1-FASA3-2 B/E-27. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4212-TC-U4C.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052910 perform SMAW Repair welding on; Cross Bracing Gusset and Back fill plate on Skin A of North shaft, Lift 3, in 109 mtr. elevation and the weld joint is identified as NSD1-FASA3-1 B/E-29. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

compliance with WPS-345+485-SMAW-4G (4F)-Repair. The Welding Repair Report (WRR) found to be WR-3608.

4. This QA inspector, Baskar This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040365 perform SMAW Repair welding on; Cross Bracing Gusset and Back fill plate on Skin A of South shaft, Lift 3, in 109 mtr. elevation and the weld joint is identified as SSD1-FASA3-1 B/E-30. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345+485-SMAW-4G (4F)-Repair. The Welding Repair Report (WRR) found to be WR-3609.

Bay no.10

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 045240 perform SAW welding on; OBG, Lift 14 Bottom panel and the weld joint is identified as SEG 3013AC- 002. ZPMC CWI Identified as Mr. LiYan Hua. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U3C-S2. (Photo attached)

6. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 057180/052075 perform FCAW welding on; OBG, Lift 14 Bottom plate and the weld joint is identified as BP 3094-001-247, 248. ZPMC CWI Identified as Mr. Liu Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as OBG Bottom panel, Lift 14 at Bay no. 10 (Notification no. 06680) and Light Bracket at Bay no. 12 (Notification no. 06677).The weld designation reviewed is as follows:

BP 3088-001 – Jt. nos -20,21,57,58,64,72,73,114 –Bottom panel, Lift 14

LB3A -002 –Jt. nos – 2,3,4,5 –Light Bracket

LB4A -002 –Jt. nos. – 2,3,4,5 –Light Bracket

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer